

Date: Friday, 30/05/2008 10:12:46 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAT FRAME ASSEMBLY
Job Number	: 39599		
Estimate Number	: 11122		
P.O. Number	:	Part Number	: D3016041
This Issue	: 30/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3016 REV A
First Issue	: 30/05/2008	Project Number	: N/A
Previous Run	: 36145	Drawing Revision	: A
		Material	:
Written By	:	Due Date	: 06/06/2008
Checked & Approved By	: <u>JUD 08.5.30</u>	Qty:	1 Um: Each
Comment	: Est. A 01.09.19 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
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Comment: Qty.: 4.5150 f(s)/Unit Total: 4.5150 f(s)
 4130 Tube .750 OD x.049W
 Cut- AISI 4130N tube, Ø3/4" x 0.049" wall
 Batch: M103012

PD 08-06-10

2.0	M4130NT1000W120	4130 Tube 1"dia .120wall
-----	-----------------	--------------------------



Comment: Qty.: 1.5750 f(s)/Unit Total: 1.5750 f(s)
 4130 Tube 1.0"D X 0.120"W
 batch M11591

PD 08-06-10

3.0	M4130NT0500W049	4130 Tube .500 OD x.049W
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Comment: Qty.: 4.5150 f(s)/Unit Total: 4.5150 f(s)
 4130 Tube .500 OD x.049W
 Cut- AISI 4130N tube, Ø1/2" x 0.049" wall
 Batch: M106651

PD 08-06-10

4.0	D301617	Gusset
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Gusset
 Pick:

Qty	Part Number	Description	Batch
2	D3016-17	Gusset	<u>B39641</u>

PD 08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:12:46 AM
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Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 39599

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D301613

Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Pick:

Qty	Part Number	Description	Batch
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2	D3016-13	Bracket	B34208
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PD 08-06-10

6.0

D301615

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D3016-15	Gusset	B25762
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PD 08-06-10

7.0

D30201

Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Fitting

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	D3020-1	Fitting	B36713
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PD 080610

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble and weld as per Dwg D3016 using welding jig DT8597

A/R 4130 Rod Batch: M100015

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

PD 08-06-10

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SEAT FRAME ASSEMBLY

Job Number: 39599

Part Number: D3016041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/06/10

11.0

POWDER COATING

POWDER COATING



M 105642



(1X)

Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

START TIME:

1'-10

OVEN TEMPERATURE:

320°F

FINISH TIME:

1'-40

M-L 08/06/10

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/06/10 (1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/06/10 (1)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12

Job Completion



MF 08-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

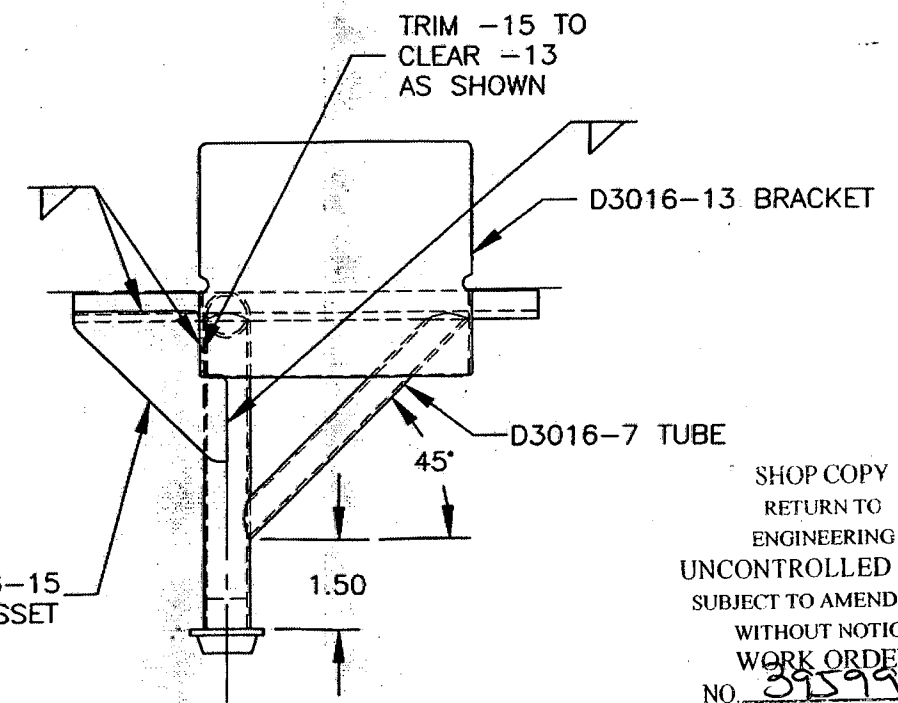
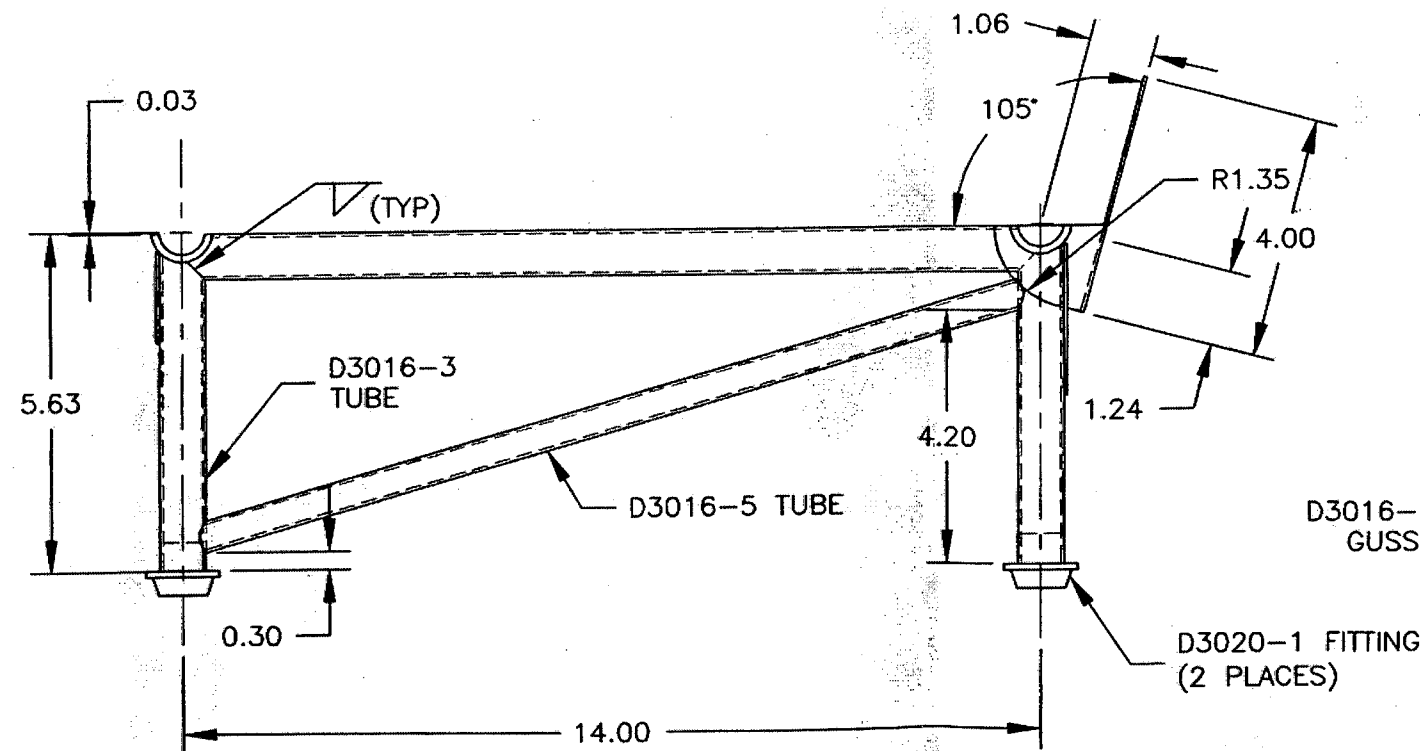
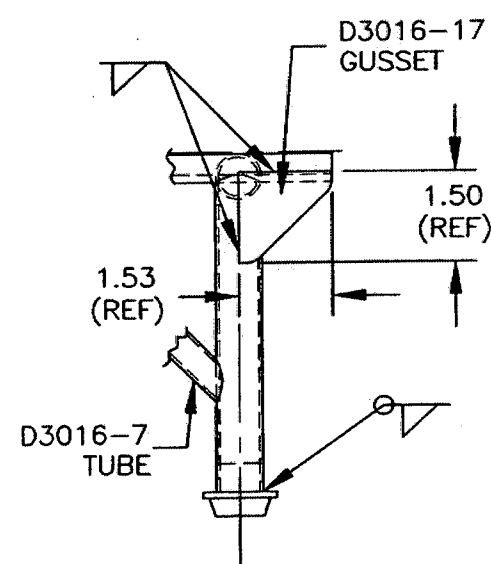
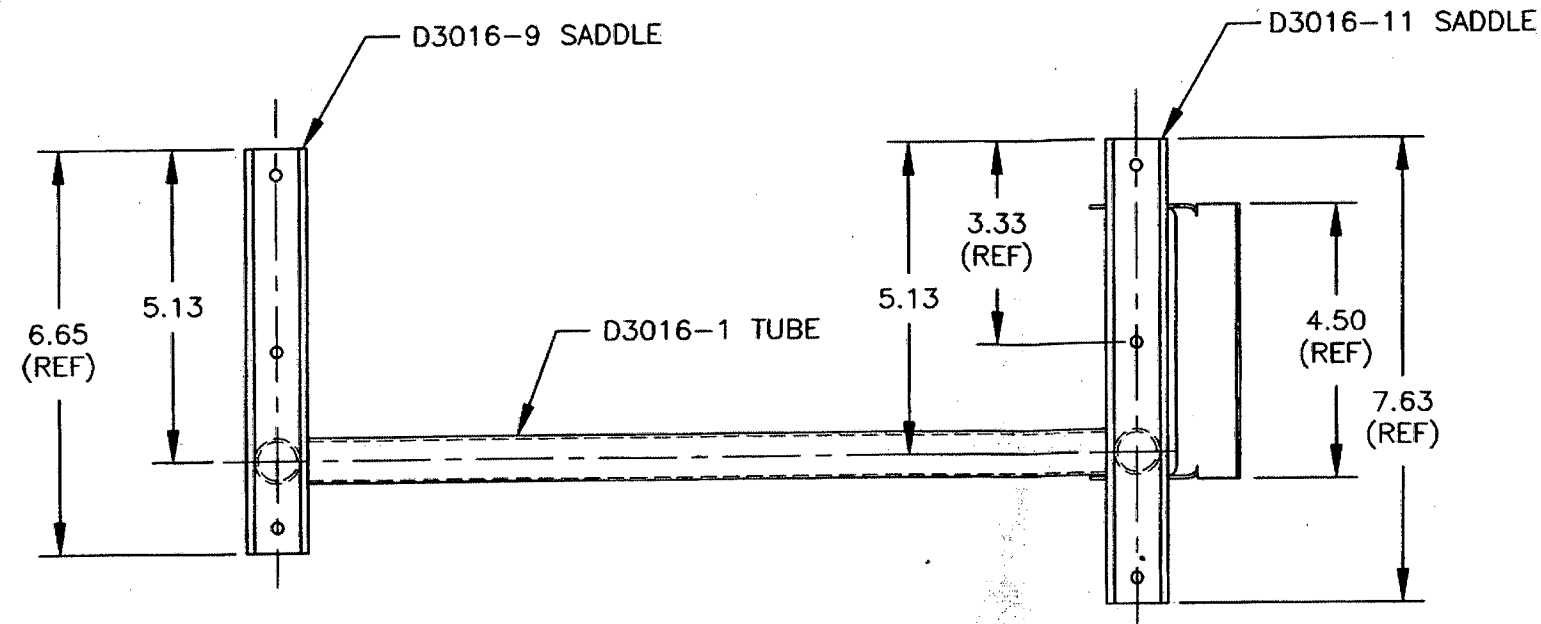
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D3016-041 SEAT FRAME ASSEMBLY



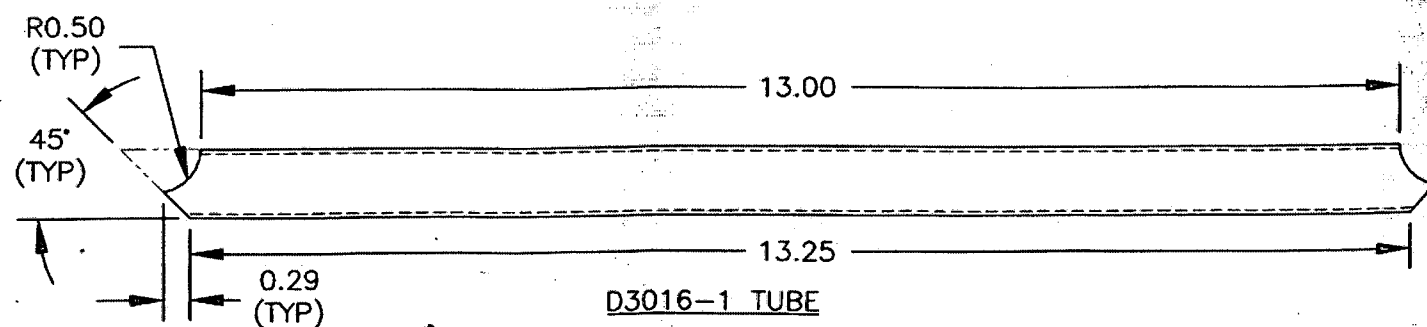
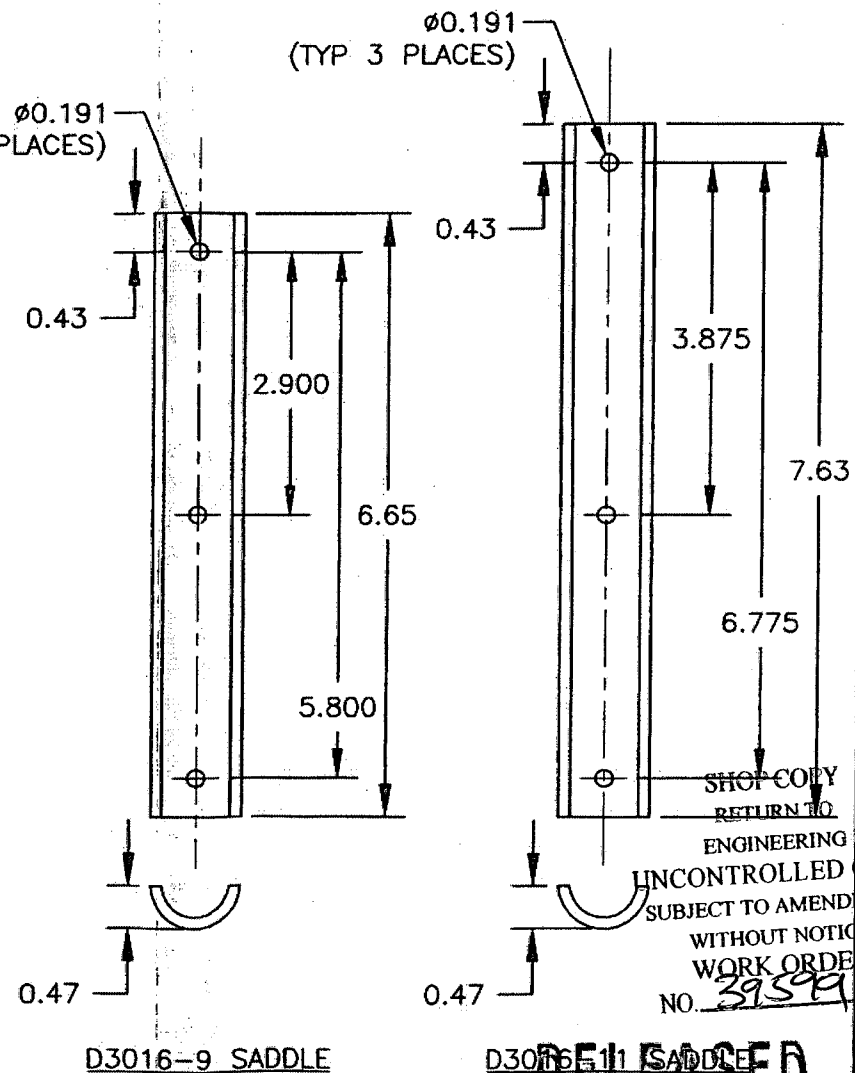
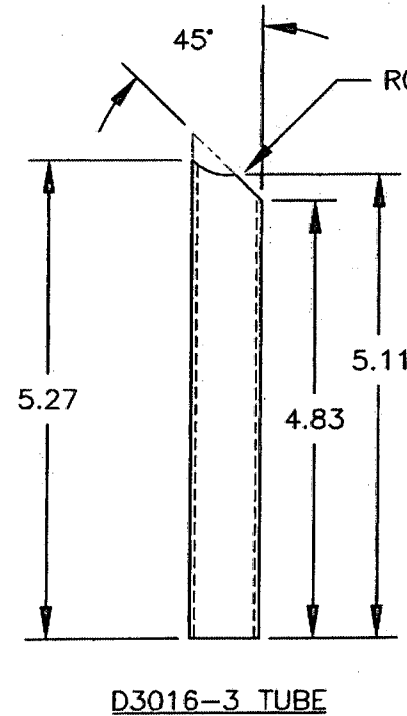
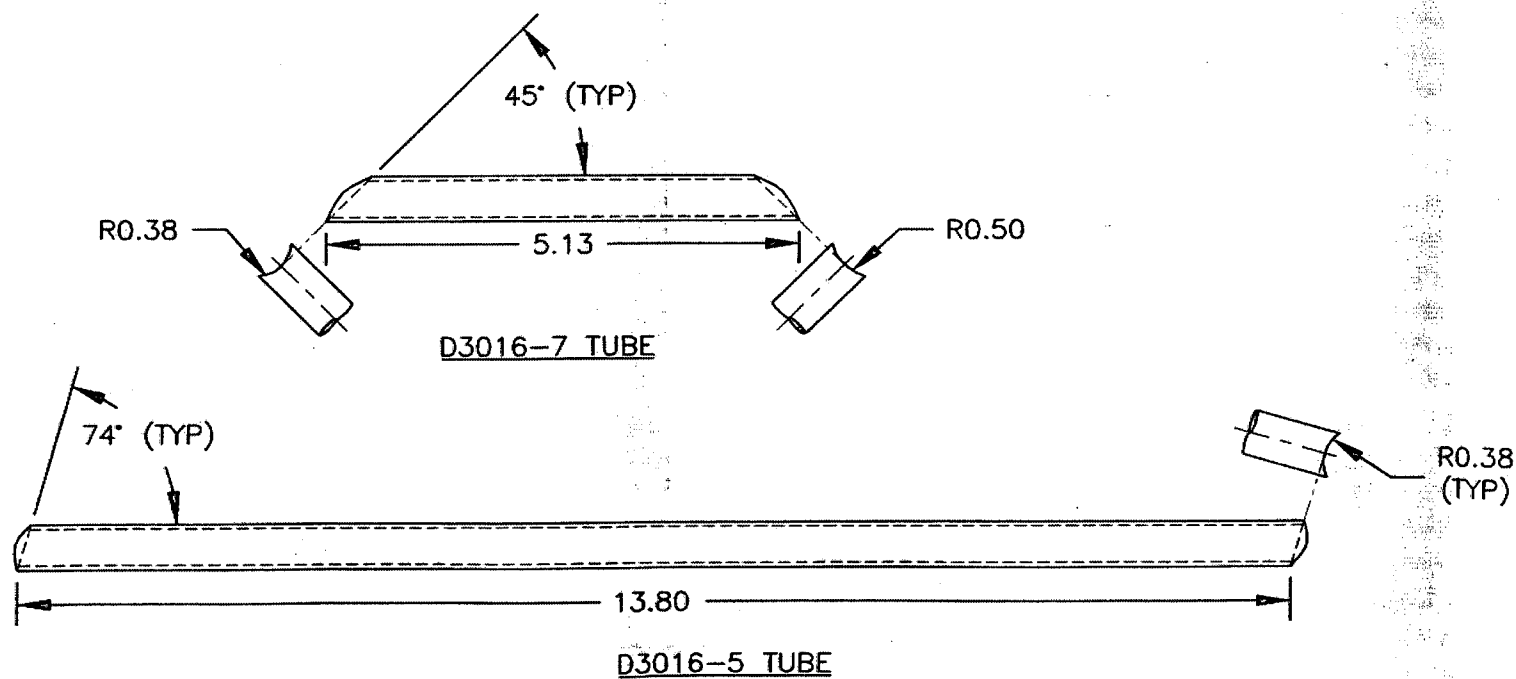
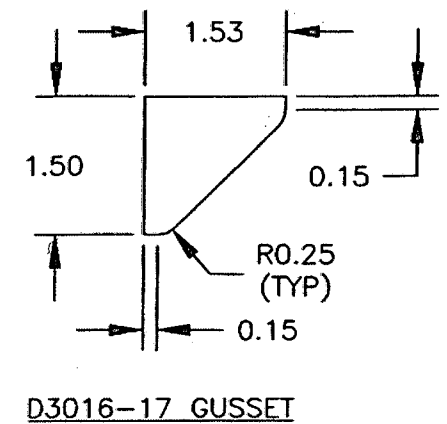
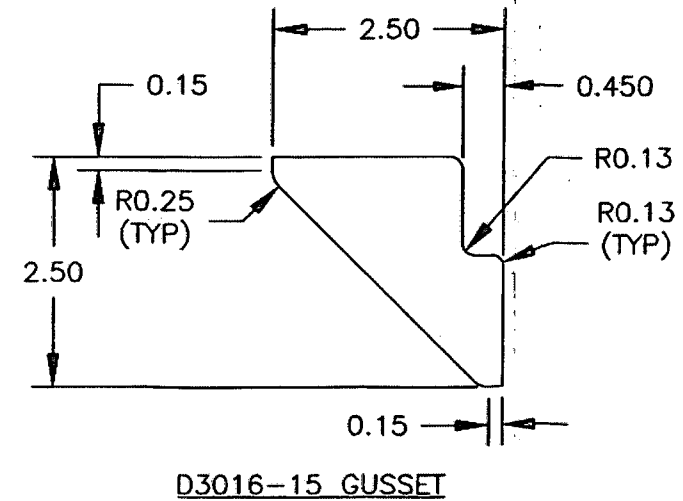
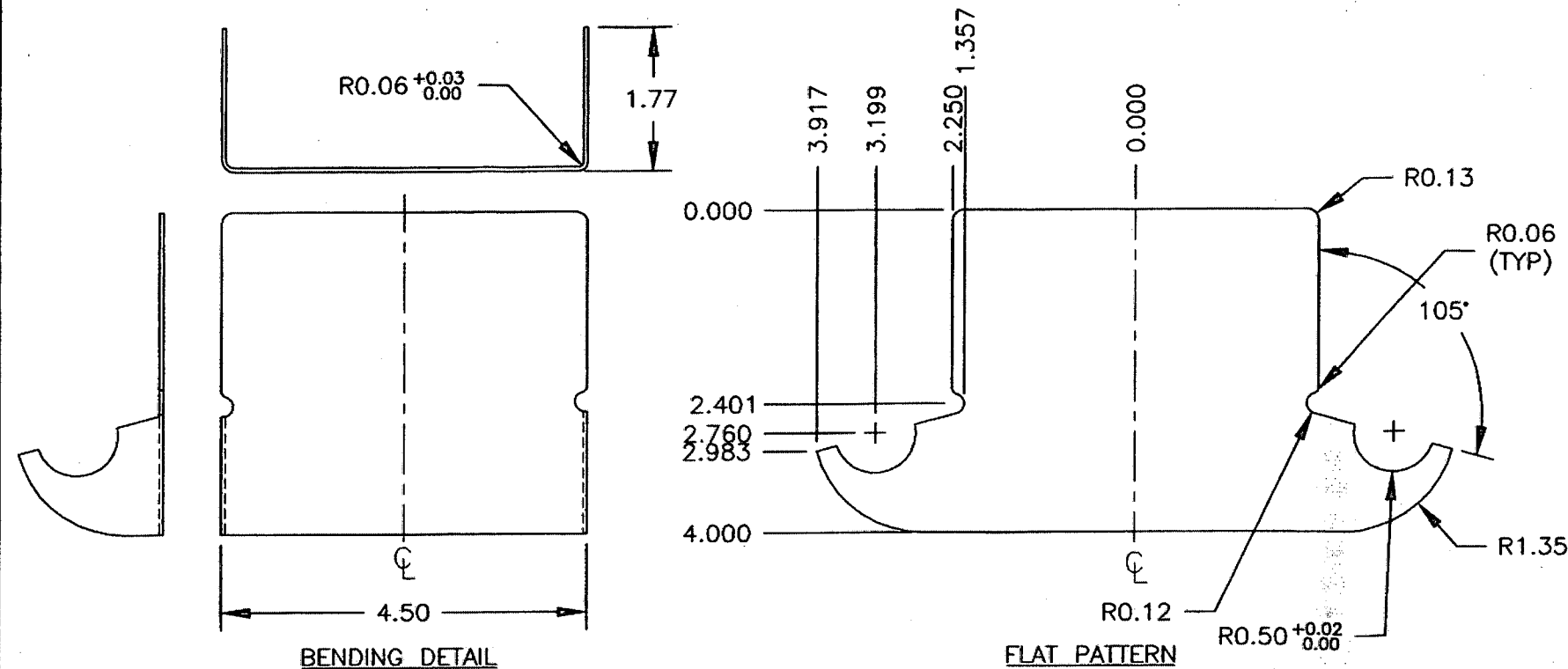
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CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A
DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY	SHEET 2 OF 3	SCALE 1:3



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		★	★	D3016	SHEET 3 OF 3
		DATE	TITLE	SCALE	
		01.05.18	SEAT FRAME ASSEMBLY	1:2	